Dart Aerospace Ltd.

Date: Thursday, 4/5/2007 11:59:18 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CROSSBOLT SPACER
Job Number	: 31696		
Estimate Number	: 10329		
P.O. Number	: N/A	Part Number	: D2743
This Issue	: 4/5/2007 S.O. No. : N/A	Drawing Number	: D2743 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 30448	Material	: N/A
Written By	:	Due Date	: 5/10/2007 Qty: 200 Um: Each
Checked & Approved By	: 07.04.05		
Comment	: Est E 05.04.13 Reformat; removed tumble and deburr step K J/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0625W065	6061-T6 Tube .625 x.065W

Comment: Qty.: 0.2800 f(s)/Unit Total : 56.0070 f(s)
Material: 6061-T6 (WW-T-700/6)
Ø0.625 " x 0.065" wall
(M6061T6T0.625W.065) Batch: 102450 DJP 07/06/03

2.0	HARDINGE	HARDINGE CNC LATHE SMALL

Comment: HARDINGE CNC LATHE SMALL
Machine as per Folio FA202 and Dwg D2743
DJP 07/06/03 204

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

204

Comment: INSPECT PARTS AS THEY COME OFF MACHINE DJP 07/06/03

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK SA 07.06.07 204

5.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_____ 07/6/7 204

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** [illegible] **Date:** 07/06/04

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/5/2007 11:59:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 31696

Part Number: D2743

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE

204

Comment: FINAL INSPECTION/W/O RELEASE

07/06/04

Job Completion

U 07-06-04

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

DART AEROSPACE LTD	Work Order:	31696
Description: Cross Bolt Spacer	Part Number:	D2743
Inspection Dwg: D2743 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.085	+0.030/-0.000	3.02	✓			
Ø0.625	+/-0.010	0.625	✓			
0.050 x 45°	+/-0.010 x 45°	0.050	✓			
0.065	+/-0.010	0.064	✓			

Measured by:	DJP
Date:	07/06/03

Audited by:	[illegible]
Date:	07/06/03

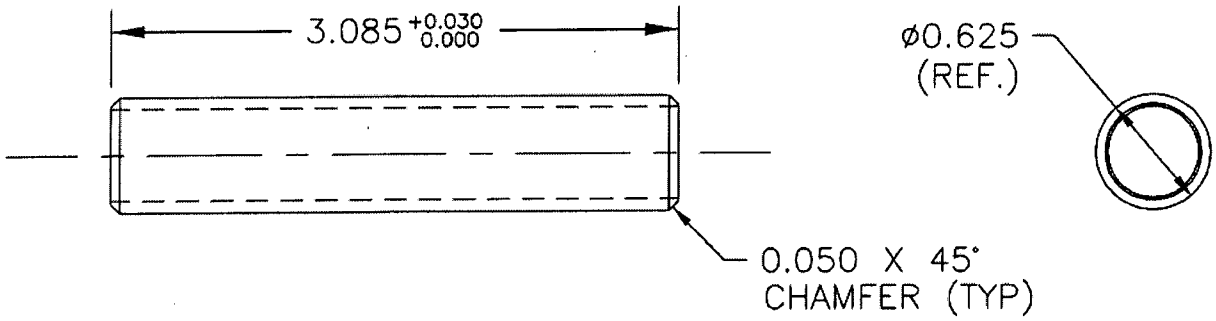
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.11.20	Tolerance +/-0.010 x 45° was 0.48 x 45°	KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED	DRAWING NO. D2743	REV. B SHEET 1 OF 1
DATE 98.12.08		TITLE CROSS BOLT SPACER	SCALE 1:1

A	98.04.16	NEW ISSUE
B	98.12.08	3.085 WAS 3.060

RELEASED 98.12.16 DS



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 31696